

Date: Tuesday, 12/12/2006 10:32:00 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 29906  
 Estimate Number : 12102  
 P.O. Number : *NIA*  
 This Issue : 12/12/2006 S.O. No. : *NIA*  
 Prsht Rev. : NC  
 First Issue : *NIA* Type : MACHINED PARTS  
 Previous Run : 27570  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : est rev. A New issue EC

Drawing Name : WHEEL ASSEMBLY

Part Number : D33975  
 Drawing Number : D3397 REV.A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : *NIA*  
 Due Date : 1/10/2007

Qty: *7* Um: *12* Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1020TR1375W125 COLD DRAWN ROUND TUBE



Comment: Qty.: 0.1313 f(s)/Unit Total : 1.5750 f(s),  
 AISI 1020-1025 ROUND TUBE  
 Dia. 1.375" x 0.125" wall batch: *M17015*

*MS 06/12/19 7*

2.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE  
 Turn as per Dwg D3397

*MS 06/12/19 7*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MS 06/12/19 7*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*MS 06/12/19 7*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: *ST431*

*06/12/20 (7)*

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/12/20 (7)*

Job Completion

*06/12/20*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

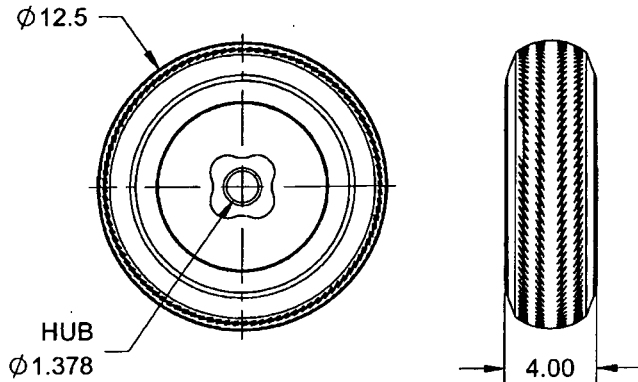
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   M   Date: 06/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

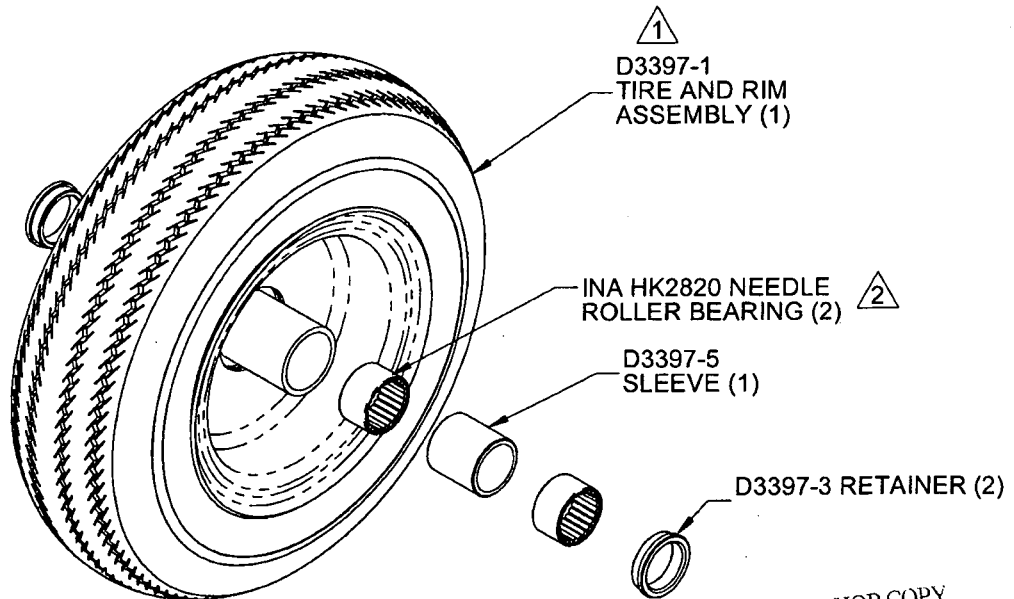
|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3397</b>                              | REV. A<br>SHEET 1 OF 3 |
| DATE<br><b>05.02.10</b>       | TITLE<br><b>WHEEL ASSEMBLY</b> |  | SCALE<br>1:8           |
| A                             | 05.02.10                       | NEW ISSUE  |                        |



| WHEEL SPECIFICATIONS                                       |              |                        |
|--|--------------|------------------------|
| SIZE   | MAXIMUM LOAD | MAXIMUM INFLATION LOAD |
| TIRE: $\phi 12.4 \times 4.1$<br>RIM: $\phi 6.0 \times 4.0$ | 445 LBS      | 50 PSI*                |

**1 D3397-1 TIRE AND RIM ASS'Y**

**RELEASED**  
*[Signature]*



**D3397-041 WHEEL ASS'Y**

**NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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NO. **29906**

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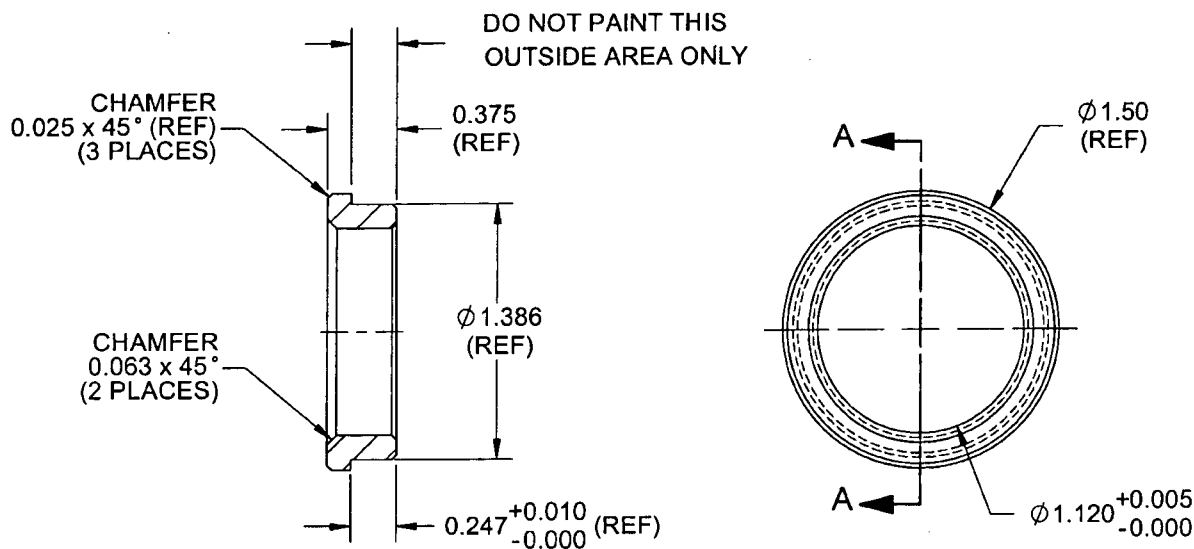
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|                               |                                |   |                        |
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| DATE<br>05.02.10              |                                | TITLE<br>WHEEL ASSEMBLY                           | SCALE<br>1:1           |

**RELEASED**  
*[Signature]* 06/03/09

## SPECIFICATION CONTROL DRAWING



**SECTION A-A**

### **D3397-3 RETAINER**

#### **NOTES:**

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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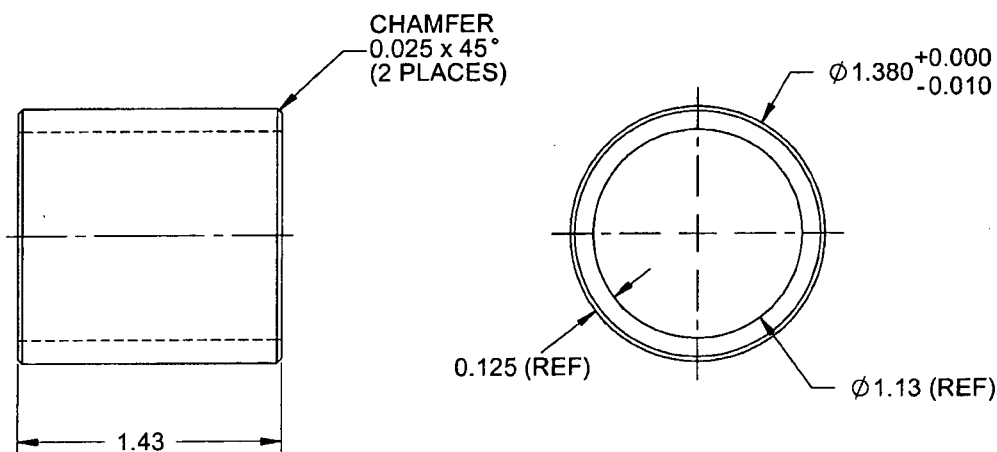
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|                         |                                |  |                        |
|-------------------------|--------------------------------|--|------------------------|
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| CHECKED<br>[Signature]  | APPROVED<br>[Signature]        | DRAWING NO.<br><b>D3397</b>                              | REV. A<br>SHEET 3 OF 3 |
| DATE<br><b>05.02.10</b> | TITLE<br><b>WHEEL ASSEMBLY</b> |  | SCALE<br>1:1           |

**RELEASED**  
R 06/03/09

[Signature]

**D3397-5 SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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|                                    |                     |             |
|------------------------------------|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>          | <b>Work Order:</b>  | 29906       |
| <b>Description:</b> Wheel Assembly | <b>Part Number:</b> | 03397-5     |
| <b>Inspection Dwg:</b>             | <b>Rev:</b>         | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

**X First Article**

## Prototype

[illegible]

|              |          |             |          |                     |  |
|--------------|----------|-------------|----------|---------------------|--|
| Measured by: | M8       | Audited by: | amf      | Prototype Approval: |  |
| Date:        | 06/12/19 | Date:       | 06/12/19 | Date:               |  |

|     |      |           |            |          |
|-----|------|-----------|------------|----------|
| Rev | Date | Change    | Revised by | Approved |
| A   |      | New Issue | KJ/JLM     |          |